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- selected from the group consisting of 65% to 95%, preferably and 70% to 80%, of the outer surface of the copper tube (3, 23).
5. (Currently Amended) Mold ~~Mould~~ according to Claim 1 ~~or 2~~, wherein ~~characterised in that~~ the copper tube ~~(3, 23)~~ has a residual wall thickness of 4 mm to 10 mm ~~in the region of~~ where the cooling ducts are located ~~(6, 26)~~.
 6. (Currently Amended) Mold ~~Mould~~ according to Claim 2, wherein ~~characterised in that in~~ the case of the mold is rectangular billet and bloom moulds and four supporting plates ~~(32—32'')~~ are releasably attached to the copper tube (23), each supporting plate ~~(32—32'')~~ butting at its an end face against one neighbouring an adjacent plate and overlapping the ~~other neighbouring~~ another adjacent plate.
 7. (Currently Amended) Mold ~~Mould~~ according to Claim 2, wherein ~~characterised in that~~ neighbouring supporting plates (32, 51, 52) adjacent to each other are screwed together in the corner regions of the copper tube (23) and form a supporting box arranged around the copper tube ~~(23)~~.
 8. (Currently Amended) Mold ~~Mould~~ according to Claim 2, further comprising ~~characterised in that~~ elastic seals ~~[(54)]~~ which allow expansions of the copper tube walls ~~are arranged in~~ overlap gaps between the supporting plates ~~(51, 52)~~.
 9. (Currently Amended) Mold ~~Mould~~ according to Claim 1 ~~or 2~~, wherein the supporting surfaces comprise ~~characterised in that the cooling ducts (6, 26) are delimited by at least one of supporting ribs (8, 28) and/or and connecting ribs that delimit the cooling ducts (9, 29) which support the copper tube (3, 23) on the supporting plates (32) or on the supporting shell (12) and/or connect it thereto.~~
 10. (Currently Amended) Mold ~~Mould~~ according to Claim 2, further comprising ~~characterised in that, for each side of the strand,~~ narrow supporting surfaces ~~10 (28')~~ are arranged along the corner regions thereof and connecting ribs (9, 29, 59) are arranged in ~~the a~~ middle region

of the ~~mold~~ ~~mould~~ sides, the connecting ribs (9, 29, 59) being provided with securing devices to prevent transverse movements ~~transversely to the strand axis~~.

11. (Currently Amended) Mold ~~Mould~~ according to Claim ~~101~~ ~~or 2~~, wherein characterised in that the securing devices are selected from the group consisting of device comprises a dovetail profile, a T-profile for sliding blocks and or a clamping device-etc.
12. (Currently Amended) Mold ~~Mould~~ according to Claim 2, wherein characterised in that the copper tube (23) has forms a curved mold ~~mould~~ cavity (24) and has curved supporting surfaces and the ~~two~~ supporting plates (32, 32'') ~~which support the curved side walls of the copper tube (23) have plane boundary surfaces at their sides (36, 36'') opposite the curved supporting surfaces.~~
13. (Currently Amended) Mold ~~Mould~~ according to Claim ~~1~~ ~~or 2~~, wherein characterised in that the cooling ducts (6, 26, 55) are milled into the copper tube (3, 23) and are closed off with a copper layer (58) produced by electrodeposition.
14. (Currently Amended) Mold ~~Mould~~ according to Claim ~~1~~ ~~or 2~~, wherein characterised in that the supporting plates (32—32'') or the supporting shell (12) consist or consists of a material selected from the group consisting of a metallic material, preferably austenitic steel, or and non-metallic material which can be easily penetrated by magnetic fields.
15. (Currently Amended) Mold ~~Mould~~ according to Claim ~~1~~ ~~or 2~~, further comprising characterised in that externally-arranged magnetic devices selected from the group consisting of electromagnetic coils (14) ~~are arranged outside the supporting plates (32—32'') or the supporting shell (12), or and moving permanent magnets are fitted into the supporting plates (32—32'') or the supporting shell (12).~~
16. (Currently Amended) Mold ~~Mould~~ according to Claim ~~1~~ ~~or 2~~, further comprising characterised in that a protective layer (57) to prevent electrolytic corrosion is arranged

